

CLAIMS

1. Method for hot rolling strip, in which the rolling stock is rolled in a reversing Steckel rolling stand (8) and is conveyed between two furnace reels (9, 10), which are arranged on either side of the Steckel rolling stand (8), by drivers (17, 18), which are arranged between the corresponding furnace reel (9, 10) and the Steckel rolling stand (8), characterized by the fact that the strip is cropped during the reversing rolling in the Steckel rolling stand (8) by means of a single flying cropping shear (20) installed between a driver (17) and the Steckel rolling stand (8).

2. Method in accordance with Claim 1, characterized by the fact that the cropped strip is rolled to final strip thicknesses of 2 mm or less in the Steckel rolling stand (8).

3. Installation for hot rolling strip with a reversing Steckel rolling stand (8), on either side of which a furnace reel (9, 10) is arranged, with drivers (17, 18), which are installed between each furnace reel (9, 10) and the Steckel rolling stand (8), and with a cropping shear, especially for carrying out the method in accordance with Claim 1 or Claim 2,

characterized by the fact that a single flying cropping shear (20) is installed between one driver (17) and the Steckel rolling stand (8).

4. Installation in accordance with Claim 3, characterized by the fact that the cropping shear (20) is a drum blade cropping shear with both an upper and lower adjustable blade drum (28a, b) for making the flying cut of the strip material, such that each blade drum (28a, b) can be adjusted between a position some distance from the strip material during the rolling operation and a cutting position.

5. Installation in accordance with Claim 4, characterized by the fact that a heat shield (41a, b) can be swung into the space between the strip material and the corresponding adjustable blade drum (28a, b), which has been moved into its position some distance from the strip material.

6. Installation in accordance with Claim 4 or Claim 5, characterized by the fact that the lower heat shield (41b) of the lower blade drum (28b) is equipped with at least one strip support roller (47), which, when the heat shield (41b) is swung into place, prevents sagging of the strip as it passes through the shear.

7. Installation in accordance with any of Claims 4 to 6, characterized by the fact that a cooling device is provided for cooling the blade drums with a coolant, and that the upper heat shield (41a) of the upper blade drum (28a) simultaneously serves as a coolant collection channel and as protection for the strip material.

8. Installation in accordance with any of Claims 5 to 7, characterized by the fact that each swiveling heat shield (41a, b) is supported on the axis of the corresponding blade drum (28a, b).

9. Installation in accordance with any of Claims 4 to 8, characterized by the fact that the blade drums (28a, b) can be swiveled between a swung-out rolling position and an engaged cutting position by means of an upper and a lower toggle mechanism (24-27a, b).

10. Installation in accordance with Claim 9, characterized by the fact that the upper and lower toggle mechanisms (24-27a, b) are combined in a closed shear frame (32).

11. Installation in accordance with any of Claims 3 to 10, characterized by the fact that a roller table area, which is located immediately adjacent to the cropping shear (20) and serves to convey the strip material through the shear, is formed

by two independently swiveling roller table units (42, 43), wherein, to allow removal of the crop end, each roller table unit (42, 43) can be swiveled out of the horizontal position in such a way that the crop end can fall freely, without hindrance by the roller table unit (42, 43), and that the roller table unit (42, 43) can then be swung further in the same swiveling direction, until it again reaches its horizontal position.